

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.12**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000677**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 25-Feb-2008**Location:** Changxing Island, Shanghai, China

Submittals(New / Total): **CWR's:** / **HSR's:** / **NCR's:** /

Item	Title	Detail
1	Major component movement	<p>OBG Production:</p> <p>Fitting and welding stiffeners to floor beams, Machining, beveling and bending closed-ribs, Fitting closed-ribs to deck panels, ZPMC performed welding of PMT #19 and Deck Panels DP-019-001 and DP-017-001. ZPMC performed the GMAW root passes to both panels prior to completing the PMT. ABF and ZPMC have not performed VT or UT of the PMT.</p> <p>Tower Production:</p> <p>Heat straightening cut diaphragm plates.</p> <p>77m Tower Mock-up:</p> <p>ZPMC performing UT of diaphragm infill plates.</p> <p>89m Tower Mock-up:</p> <p>ZPMC performed UT on the Shear Links.</p> <p>114m Tower Mock-up:</p> <p>Drilling holes for tower splice. ZPMC has welded Stabbing lugs to the lower section. This is not shown on the fabrication procedures.</p>
2	Meetings attended	<p>Caltrans met with ABF and ZPMC at the request of ZPMC's Quality Manager Chen Bin to discuss the measurement of overlap. Caltrans and ABF met previously to discuss the measurement of overlap and came to the consensus to use a square or steel rule held in contact with the weld and deck plate and observe visible light leaks at the weld toe. Both Caltrans and ABF have been using this method to identify overlap and have had consistent results. Results from ZPMC's inspection have differed considerably from Caltrans and ABF results. ZPMC stated they have not</p>

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been using this method, but instead were comparing the welds with welding samples which show gross overlap, marginal overlap and acceptable weld. ZPMC has been using the “marginal overlap” samples as their acceptance criteria. Caltrans stated that the code did not allow for any overlap, and that the agreed upon method for determining overlap areas was the light leak test.

Caltrans stated that, although this test is stringent, it eliminates subjectivity in the inspection. Caltrans, ABF and ZPMC agreed to look at a production deck panel tomorrow at 9 a.m. to train ZPMC and ensure the inspections are consistent.

3	Logistics	ZPMC has still not restored the 0630 and 2230/2300 ferries. This restricts the method of shift coverage available and results in no overlap between the 2nd and 3rd shifts.
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Inspected By:	McClary,David
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Quality Assurance Inspector

Reviewed By:	Lowry,Patrick
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QA Reviewer
